



Dart Aerospace Ltd.
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000158

D2873-043
Job Sheet 170060



Part No: D2873-043

Job Qty: 60 ea

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 1/8/18

Job Tracking No:

Due Date: 1/15/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea		1/12/18	0.00	0.00	Start Up Machining-1		Kt-18-01-24
100	Bandsaw	60 pcs		1/12/18	0.00	0.29	Bandsaw1		Kt-18-01-24
110	CNC Vertical Machining	60 pcs		1/13/18	0.04	15.83	HAAS1-2		Kt-18-01-24
120	QC	60 pcs		1/13/18	0.00	0.00	QC2 Machining-1		Kt-18-01-24
130	QC	60 pcs		1/13/18	0.00	0.00	QC8 Machining-1		Kt-18-01-24
140	Small Fab	60 pcs		1/13/18	0.00	2.03	Small Fab-2		Kt-18-01-24
150	QC	60 pcs		1/13/18	0.00	0.00	QC5		Kt-18-01-24
160	HandFinish	60 pcs		1/13/18	0.00	0.75	HandFinish1		2018/01/25 JSC
170	QC	60 pcs		1/13/18	0.00	0.00	QC7-1		2018/01/25 JSC
180	Small Fab	60 pcs		1/15/18	0.00	2.03	Small Fab-2		2018/01/25 JSC
190	QC	60 pcs		1/15/18	0.00	0.00	QC5		2018/01/25 JSC
200	Packaging	60 pcs		1/15/18	0.00	0.00	Packaging3-1		2018/01/25 JSC
210	QC21-SA	60 Ea		1/15/18	0.00	0.00	QC21		2018/01/25 JSC

Part Op 100 - Cut blanks: 1.000" x 0.375" x 3.700" long

Descriptions: 110 - Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev ____ Folio Rev ____

140 - 1-Deburr 2- C'sink as per Dwg D2873

180 - 1-Assemble as per Dwg D2873 2-Identify as D2873-043

200 - LOCATION : LG050

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B0.375X01.000	18	0	0	0
180-Small Fab	MS20426AD4-6 FM138621	360	1,911	0	0
	MS21075L5 5004850	180	484	0	0

Part Specifications

Specifications could not be found.

Plex 1/8/18 3:55 PM dart.poulin.mario

Mazak?

5033411 - 18.675

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
Date: _____		As-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Description: _____				Large Fab ☐	Composite ☐	Supplier ☐	
				Effective: _____			
				MRB (QSI042) Approval			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			

S034892

Nut Plate Assembly

PART NO: D2873-043

Original Serial #: S034892

Revision:

Operation:

Change No:

Start up Operation

Job No: 170060

01/24/18

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Bending	☐
Centre Not Concentric	☐
Cracks	☐
Crimp/Kink/Ripple/Wave	☐
Cuffs	☐
Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐

Operation 01/24/18

Job No: 170060

Power Loss/Surge	☐	Positioned Wrong	☐
olio/Program	☐	Outside Dimensions	☐
Brain	☐	Over/Under tolerance	☐
Weld	☐	Part Incorrect	☐
Wrong Stock Pulled	☐	Part Lost/Missing	☐
Out of Sequence	☐	Part Moved	☐
Off-set	☐	Drawing	☐
Mislabeled	☐	Finish	☐
Fit/Function	☐	Misread	☐
Misaligned/off center	☐	Turning Sequence	☐

OTHER: _____

DART AEROSPACE LTD		Work Order:	170060
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500	✓		Kt-05	verm
2.000	+/-0.010	2.000	✓		" "	" "
0.750	+/-0.010	0.749	✓		" "	" "
1.000	+/-0.010	1.000	✓		" "	" "
0.250	+/-0.010	0.250	✓		" "	" "
1.000	+/-0.010	1.00	✓		" "	" "
2.000	+/-0.010	2.000	✓		" "	" "
3.000	+/-0.010	3.000	✓		" "	" "
Ø0.128	+0.005/-0.001	0.129	✓		" "	" "
0.359	+/-0.010	0.359	✓		" "	" "
Ø0.316	+0.006/-0.001	0.316	✓		" "	" "
1.000	+/-0.010	1.001	✓		" "	" "
0.250	+/-0.010	0.249			" "	" "
0.061	+/-0.010	0.058	✓		" "	" "
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0.230 x 0.125	✓		" "	" "

Measured by:	DAS 1 8-89 Kt	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	18-01-24	Date:	18/01/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM [Signature]	[Signature]